

# Work Order ID 53381

November 3, 2009 8:53:17 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 03/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*PS*

Date:

*09-11-3*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825□2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825□3- c'sink hole as per dwg□4- remove identification markings□5- deburr

*SAP 09-11-06*

*6*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*S couldnt inspect parts were complete 11/4/06 See NCR on next page ->*

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825□ A/R ER316 S.S. Rod Batch: *4109213* □2- grind bushing weld flush where indicated on dwg D3825 □3- deburr if necessary

*84 09/11/06*

*6x*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3825-041 PAR #: D2221 → D350-607 Fault Category: Large Fals NCR: (Yes) No DQA: / Date: 05-11-25  
 Resolution: Accepted Disposition: USE AS IS QA: N/C Closed: / Date: 05-11-25

| NCR: 53381 |          | WORK ORDER NON-CONFORMANCE (NCR)  |                                 |   |                   |                           |                       |                          |
|------------|----------|---|---------------------------------|---|-------------------|---------------------------|-----------------------|--------------------------|
| DATE       | STEP     | Description of NC<br>Section A  | Corrective Action Section B     |   |                   | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|            |          |   | Initial<br>Chief Eng            | Action Description<br>Chief Eng   | Sign &<br>Date    |                           |                       |                          |
| 9/11/06    | #100/120 | Parts were not inspected at step #110. Step was over looked due to employee thinking it wasn't important. | CP<br>09.11.06<br>per<br>AS 042 | -Retrain All "welders" that inspection are important.                                     | PD/EL<br>09/11/06 | S<br>09.11.25             | AS 042                | S<br>09.11.06            |
|            |          | Parts made by ASig. R.C. L.O.A.   | CP<br>05.11.06<br>per<br>AS 042 | -Parts All measure fine - were unable to measure the hole size. Acceptable one time only. | S<br>09.11.06     | B<br>09.11.06             | AS 042                | S<br>09.11.06            |
|            |          |   |                                 |   |                   |                           |                       |                          |

NOTE: Date & initial all entries



**Work Order ID 53381**

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Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 03/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09 *[Signature]*MF  
09-11-06

# Picklist Print

November 3, 2009 8:53:21 AM

Page 1

Work Order ID: 53381

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)

Comments:

Start Date: 03/11/2009

Required Date: 09/11/2009

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2327-3RevD

Manufactured

No

100

Each

40.0000

6.0000



Spacer Bushing

SAD 09-11-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

44274

21

44365

9

51126

10

6x 09/11/06

D3759-1RevA

Manufactured

No

100

Each

52.0000

6.0000



Bushing

SAD 09-11-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

52

51136

16

51473

36

6x 09/11/06

M304TS0.750W.065

Purchased

No

100

f

191.8453

13.4211



304 SQ Tube .75x.75x.065W

8 SAD 09-11-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

191.8452947

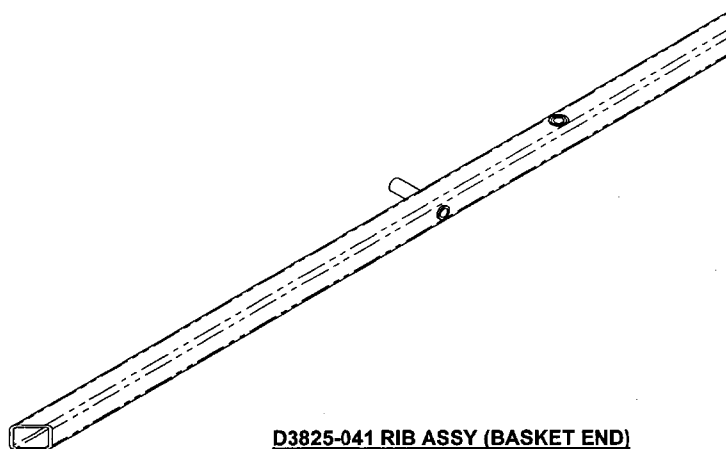
112398

191.845295

13.4211 09/11/06

End Bar Scrap 3.2 Sqft B# 112398

| ITEM | QTY | P/N       | DESCRIPTION               |
|------|-----|-----------|---------------------------|
| 1    | X   | D3825-041 | RIB ASSEMBLY (BASKET END) |
| 2    | 1   | D2327-3   | SPACER BUSHING            |
| 3    | 1   | D3759-1   | BUSHING                   |
| 4    | 1   | D3825-1   | RIB                       |



**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 58381  
080911-3

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

|            |             |    |          |
|------------|-------------|----|----------|
| A          | NEW ISSUE   | MB | 08.09.23 |
| REV.       | DESCRIPTION | BY | DATE     |
| DESIGN     |             |    |          |
| DRAWN      |             |    |          |
| CHECKED    |             |    |          |
| MFG. APPR. |             |    |          |
| APPROVED   |             |    |          |
| DE APPR.   |             |    |          |
| DATE       | 08.09.23    |    |          |

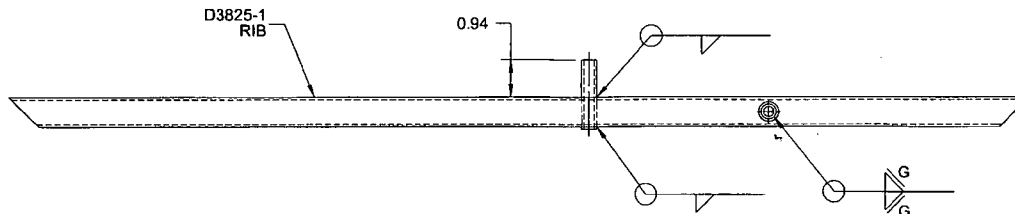
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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D3825-1  
RIB

0.94



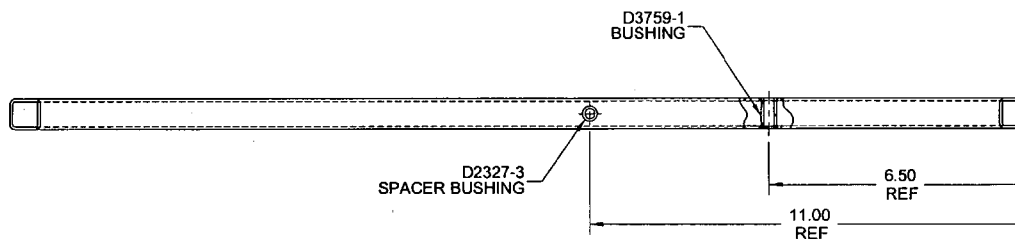
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WORK ORDER  
NO. 53381

D3759-1  
BUSHING

D2327-3  
SPACER BUSHING

6.50  
REF

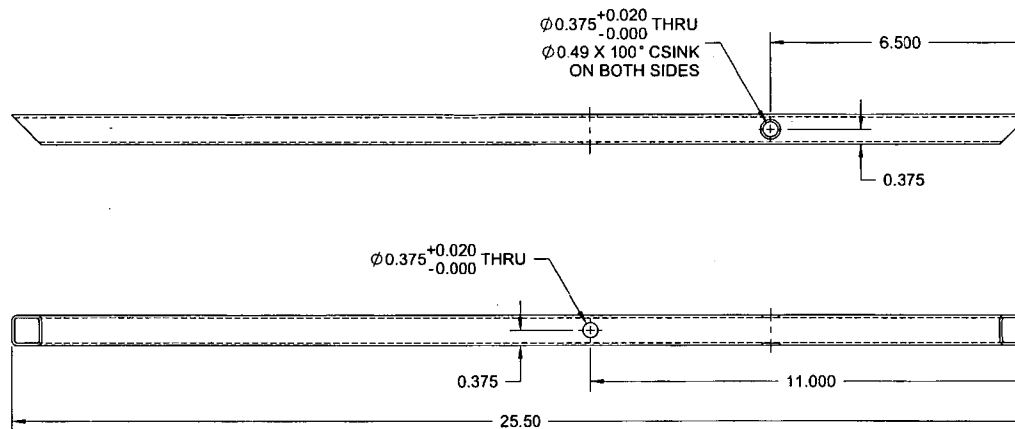
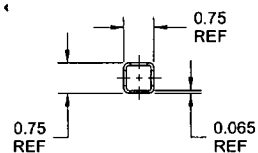
11.00  
REF



**D3825-041 RIB ASSY (BASKET END)**

**RELEASED**  
08/11/18 JVV

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3825   | SHEET 2 OF 3 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | RIB ASSY (BASKET END)   | NTS          |
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**D3825-1 RIB**

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SUBJECT TO APPROVAL  
WITHOUT  
WORK ORDER  
NO. 53381

**RELEASED**  
08/11/13

- NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.18 lbs

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3825   | SHEET 3 OF 3 |
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